



Dart Aerospace Ltd.
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D350-591-312
Job Sheet 173606



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/5/18

Job Tracking No:

Due Date: 7/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/18/18	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	10 pcs		7/19/18	0.00	10.00	Large Fab 2		C.Lu
120	QC	10 pcs		7/19/18	0.00	0.00	QC9		18-05-01
130	QC	10 pcs		7/19/18	0.00	0.00	QC5		18-05-01
140	HandFinish	10 pcs		7/19/18	0.00	1.87	HandFinish1		18-05-01
150	QC	10 pcs		7/19/18	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs		7/19/18	0.00	10.00	Large Fab 2		SLU
190	QC	10 pcs		7/19/18	0.00	0.00	QC10		CPC
200	QC	10 pcs		7/19/18	0.00	0.00	QC5		CPC
210	HandFinish	10 pcs		7/19/18	0.00	1.87	HandFinish1		18-05-08
220	Powdercoat	10 pcs		7/19/18	0.00	2.98	Powdercoat1		18-05-09
230	HandFinish	10 pcs		7/20/18	0.00	1.87	HandFinish3		18-05-10
240	QC	10 pcs		7/20/18	0.00	0.00	QC3		38
250	Packaging	10 pcs		7/20/18	0.00	0.00	Packaging1-3		9-89
260	QC	10 pcs		7/20/18	0.00	0.00	QC4		7.10
265	DC	10 pcs		7/20/18	0.00	0.00	DC		SmP
270	Packaging	10 pcs		7/20/18	0.00	0.00	Packaging3-1		
280	QC21-FG	10 Ea		7/20/18	0.00	0.00	QC21		MAY 11 2018

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M1 38673 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 1:45 OVEN TEMPERATURE: 300 FINISH TIME: 2:15

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

#2776 #2980

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	8049922
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	5050520
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	5064630
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	5059498
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab	5051986
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab	5041171
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging	5047231
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging	5062311
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging	5048292
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging	5066360
D2618	Bushing	20 Ea (2 ea)	250-Packaging	5043411X6 5049859X1
D2856-400	Abrasion Strip 4" Wide (Per Foot)	12 Ea (1.2 ea)	250-Packaging	5049650
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging	5052650
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging	5067940
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging	5053518
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging	5053518
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging	5041167
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging	5015269
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging	5055952
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging	5037030

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	41	0
	D3219-1	20	55	0
	D3272-1	10	0	0
180-Large Fab	D3065-041	10	22	0
	D3066-1	20	10	0
	MS20600-AD4W4	160	1,681	0
250-Packaging	AN3-35A	20	312	0
	AN4-13A	80	941	0
	AN5-36A	20	148	0
	D2230-3	40	65	0
	D2618	20	214	0
	D2856-400	12	72	0
	D3235-1	20	6	0
	D3278-041	10	7	0
	MS21042L3	20	3,284	0
	MS21042L4	80	3,884	0
	MS21042L5	20	849	0
	NAS1149D0363J	40	3,378	0
	NAS1149D0463J	160	5,081	0
	NAS1149D0563J	40	1,290	0

Part Specifications

Specifications could not be found.

Plex 3/5/18 4:01 PM Dart.Gagnon.Michelle

003143



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Container No: S064868



Part: D350-591-312

Job No: 173606

Serial No/Batch: S064868

Revision:

Inspector:

Date: 04/25/18

Change Record

PAGE 1 OF 1

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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